

Date: Wednesday, 12/12/2007 11:37:02 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 36279  
Estimate Number : 12651  
P.O. Number :  
This Issue : 12/12/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1 / Type : SMALL /MED FAB  
Previous Run : 31633  
Written By :  
Checked & Approved By :  
Comment : Est Rev : A New Issue 07-01-16 JLM  
est rev B revB dwg 07.04.18 ec

Drawing Name : R44 WEARPLATE  
Part Number : D35651  
Drawing Number : D3565 REV  
Project Number : N/A  
Drawing Revision : B  
Material :  
Due Date : 1/10/2008 Qty: 40 Um: Each

1007.12.12

POSTIVE  
RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



16.5396

Comment: Qty.: 0.3759 sf(s)/Unit Total : 15.0360 sf(s)

304/316 .060 Sheet

Batch: 105997 1307-12-14

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3565

Dwg Rev: B

Prog Rev: B

1307-12-14

2-Deburr if necessary

1307-12-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1307-12-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



P10

Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form "Cups" using DT8902 FORMING TOOL.

2-Gen Holes to .257" as per Dwg D3565, after forming.


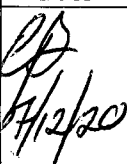
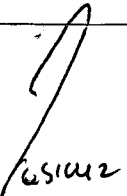
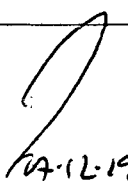
N/A

12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-19	2.0	Parts are scrap. Flat pattern is no good, and hole spacings are to wide for the new procedure. R.C. kept same pattern to press form to compensate for material shrinkage.		Scrap, destroy Qty 40 All parts No replace	 11/2/20	SB 07/12/20	 651112	 07-12-19

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 WEARPLATE

Job Number: 36279

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*n/a*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard facing as per Dwg D3565 using DT8903 Holding Plate

*Weld Cops ASPENDWg D3665 Rev C.*

A/R 2059B Hard Coat rod Batch: *J*

8.0

DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

AUTH *U*

RELEASED

DATE

*27-1. Pick QH3. D3009-1 Cyp. Batch: \_\_\_\_\_*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

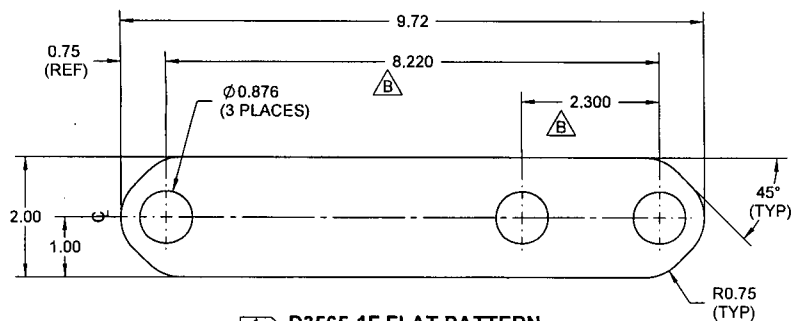
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

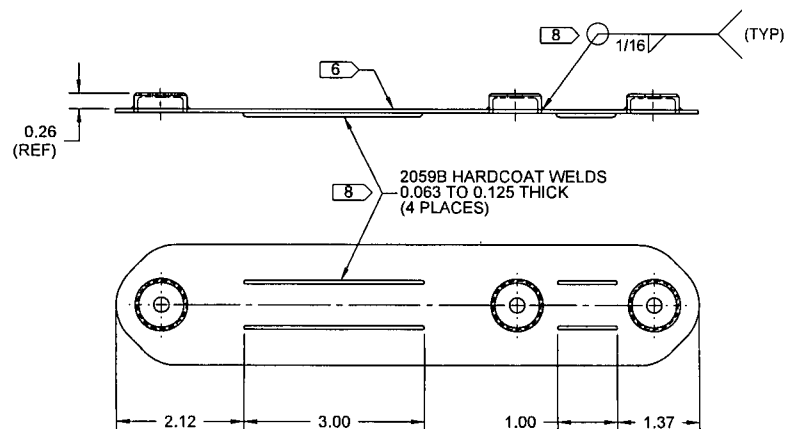
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



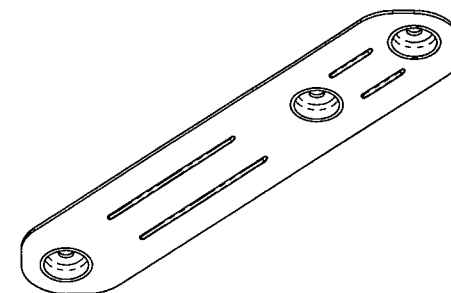


1 D3565-1F FLAT PATTERN



C D3565-1 R44 WEARPLATE

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.38 lbs
  - 8) WELD PER DART QSI 004
  - 9) PART IS SYMMETRIC ABOUT  $\phi$



C D3565-1 PARTS LIST

QTY	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	R44 WEARPLATE
3	D3009-1	CUP

PRELIMINARY ISSUE

C	WEARPLATE NOW WELDED; ADDED PARTS LIST; UPDATED NOTES	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.14		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C  
D3565 SHEET 1 OF 1  
TITLE SCALE  
R44 WEARPLATE 1:2

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